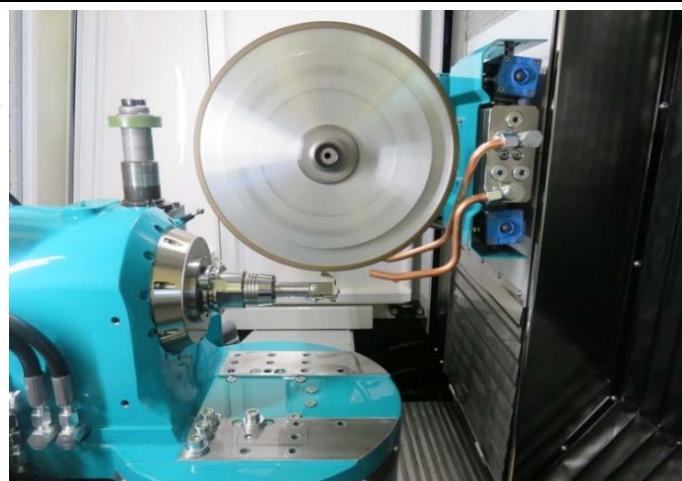


Top Notch Insert Ø12.4

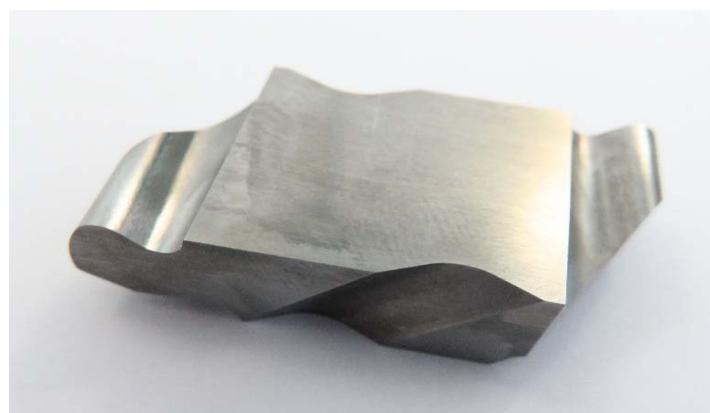
A08-150

Roughing is done with a standard 14V1 wheel with diameter 300mm and grain D64 and standard profiling process. The finishing process is grinding with an additional oscillation. Resolution 0.01 mm and oscillationlength 19 mm. The cycle time below is mentioned per side.



1. Cycletime for Production

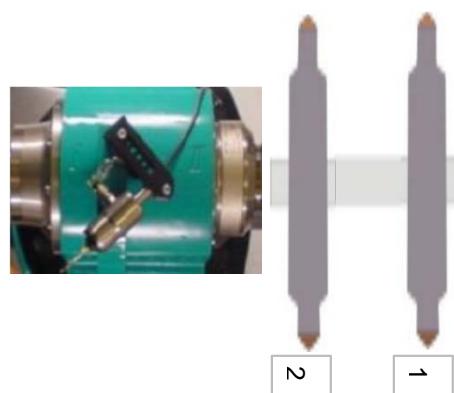
Workpiece:	40x17.5x9.35 gagerollØ12.4	
Material CARBIDE		
Operations	Prf Pgrd	Prf fin
Feed [mm/Min]	10	8000
Power [kW]	1	1
Cutting speed [m/s]	22	22
Used wheels	1	2
Grinding time [s]	332	1258
Total cycle time	26 Min 30	



The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	14V1 Ø300 D64
2	14V1 Ø300 D46M



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : sirius NGS

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31iB 5

Software: Quinto 5

Accessories: CTC for Topnotch

Responsible engineer: OP, 28.4.16

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